

Work Order ID 135176

Wednesday, September 16, 2015 12:48:41 P

135176

Page 1

Item ID: D135-692-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 7/31/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/3/2015 Req'd Qty: 1.00 ***1*** Customer: CBOND01
 Reference: RMA RA112083

Approvals: Process Plan: UME Date: 5-9-16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3049	Rev A1								

100 0.00
100
 QC Memo 0.00
 Quality Control INSPECT RA112083
 D135-692-011 X 1 B22131
 D2519 WAS RETURNED BROKEN AND TWISTED.
 DAMAGE IS BEYOND REPAIR
 SCRAP

DAS
38
9-89
SEP 21 2015

110 QC21- Final Inspection - Work Order Release 0.00
110
 QC Memo 0.00
 Quality Control

Scrap

20150921

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
OTHER : _____											

Picklist Print

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Work Order ID: 135176

135176

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 7/31/2015

Required Date: 8/3/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C04.02.17Blank size changed, Tolerance added Step
3KJ/JLM IPP REV:E AS PER DSI
9592/9587 REV A JLM VERIFIED BY:EC
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D135-692-011		Manufactured	No				Each	4.0000		1			

D135-692-011

Bearpaw

Location

Loc Qty

Loc Code

FG013

4

134871

2

136306

2

1 x 22131 mf 15-9-16

DQA: _____ Date: _____



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Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
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Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

RA112083

Received @ June 29, 2015
Inspected@ July 29, 2015

CUSTOMER: BOND AIR SERVICES
CUSTOMER CONTACT: JIM REMFRY
SHIPPED FROM: BOND AIR SERVICES

Instructions for RA112083 D135-692-011 B22131

- Customer claims bearpaw was lost in flight
- D2519 was return broken and all twisted. Looks like they were torn apart
- Excessive wear throughout the bearpaw and dragging marks was found on back section of bearpaw
- In accordance to ICA-135-692 D135-692-011 is damage beyond repair

Time Estimate: 1 hour

Departments Required: quality

Pictures Attached: yes

QTY INSPECTED: D135-692-011 B22131

**THIS INSTRUCTION SHEET
MUST BE ATTACHED TO THE**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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